



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2570

Job Sheet 209221



Part No: D2570

Job Qty: 200 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 5/15/20

Description:

Type: Stock

Note: DWG REV B IPP E 02.08.29 Re-format; Removed finishing; Material change KJ IPP F 07.07.06 rev B dwg EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	200 pcs		5/15/20	0.50	6.90	Hardinge - 1		ML 20/05/11
110	QC 2	200 pcs		5/15/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		ML 20/05/11
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S276817



Part: D2570

Job No: 209221

Serial No/Batch: S276817

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/11/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

120	QC 8	200 pcs	5/15/20	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	DAS
					QC 8 - 33	33 20/05/11
					QC 8 - 35	9-89
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
130	Packaging 3-1 - Stock - B4B	200 pcs	5/15/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	200 pcs	5/15/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
				Broussard	
					MAY 11 2020 DAS 70 9-89
Part Op 100 - (Hardinge)Machine as per folio FA258 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - LOCATION : ST008 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R0.750	303 Round Bar 0.750	13.2000 ft (.066 ea)	100-Hardinge - 1	S265823	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M303R0.750	13	46	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.800inches ± 0.010	0.810 0.790		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010		
4	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423		
5	Bushing	0.257inches + 0.006 - 0.001	0.263 0.256		
6	Bushing	0.750inches ± 0.010	0.760 0.740		
7	Bushing	0.030inches ± 0.010	0.040 0.020		
8	Bushing	20.000Degrees ± 0.000	20.000 20.000		

Plex 4/16/20 10:44 AM Dart.lajeunesse.marie

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		QTY Affected :		MRB (QS1042)																																																																									
Date :		Sequence #:		Rework Scrap Use-as-is		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging																																																																									
Description Work Order Deviation		Disposition		Completed By		Lead hand / Supervisor		QC / QA Coordinator																																																																									
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		<table border="1"><tr><td>Pressure/Forced</td><td></td></tr><tr><td>Bending</td><td></td></tr><tr><td>Crushing</td><td></td></tr><tr><td>Cracks</td><td></td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td></td></tr><tr><td>Marks/Chatter</td><td></td></tr><tr><td>Mislabeled</td><td></td></tr><tr><td colspan="2">Other/Details:</td></tr></table>		Pressure/Forced		Bending		Crushing		Cracks		Crimp/Kink/Ripple/Wave/Twist		Marks/Chatter		Mislabeled		Other/Details:		FAULT CATEGORY <table border="1"><tr><td>Contamination</td><td></td></tr><tr><td>Misaligned/off center</td><td></td></tr><tr><td>BOM/Route</td><td></td></tr><tr><td>Broken/Damage/Defect</td><td></td></tr><tr><td>Incomplete/Unclear Instructions</td><td></td></tr><tr><td>Drill Holes</td><td></td></tr><tr><td>Fit/Function</td><td></td></tr></table>		Contamination		Misaligned/off center		BOM/Route		Broken/Damage/Defect		Incomplete/Unclear Instructions		Drill Holes		Fit/Function		<table border="1"><tr><td>Power Loss/Surge</td><td></td></tr><tr><td>Folio/Program</td><td></td></tr><tr><td>Grain Direction</td><td></td></tr><tr><td>Weld</td><td></td></tr><tr><td>Wrong Stock Pulled</td><td></td></tr><tr><td>Out of Sequence</td><td></td></tr><tr><td>Off-set/Set-up</td><td></td></tr></table>		Power Loss/Surge		Folio/Program		Grain Direction		Weld		Wrong Stock Pulled		Out of Sequence		Off-set/Set-up		<table border="1"><tr><td>Positioned Wrong</td><td></td></tr><tr><td>Outside Tolerance</td><td></td></tr><tr><td>Drawing</td><td></td></tr><tr><td>Finish</td><td></td></tr><tr><td>Part Lost/Missing</td><td></td></tr><tr><td>Misread</td><td></td></tr></table>		Positioned Wrong		Outside Tolerance		Drawing		Finish		Part Lost/Missing		Misread	
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